

Date: Monday, 02/03/2009 11:42:20 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : INLET ADAPTER
 Job Number : 46215
 Estimate Number : 12160
 P.O. Number :
 This Issue : 02/03/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : SMALL / MED FAB
 Previous Run : 35144
 Written By :
 Checked & Approved By : JLD 09.03.02
 Comment : Est Rev: A New Issue 06-02-02 JLM
 Est Rev: B 09-02-17 rev.b as per dwg DD verified by: EC

Part Number : D3479041
 Drawing Number : D3479 REV.B
 Project Number : N/A
 Drawing Revision : B
 Material :
 Due Date : 09/03/2009 Qty: 4 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D34791 Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3479-1 Tube 44625

(4)

FF 09-04-02

2.0 D34793 Tab, 99 degrees



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3479-3 Tab 46274

(4)

FF 09-04-02

3.0 D34795 Tab, 81 degrees



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3479-5 Flange 46274

B347902x2
B347902x2

FF 09-04-02

4.0 D34797 Flange Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3479-7 Tab 46275

FF 09-04-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 02/03/2009 11:42:21 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INLET ADAPTER

Job Number: 46215

Part Number: D3479041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3479

2-Spot Weld as per Dwg D3479 and Dart QSI 018

PTD

(4)

FF 09-04-02

6.0

QC11

VISUAL INSPECTION OF SPOT WELDING



Comment: VISUAL INSPECTION OF SPOT WELDING

SB 09/04/24
~~SB 09/04/02~~

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

509/06/24 (X4)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with a permanent fine point marker and Stock

Location: *205*

9/06/24

(42)

54

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/24


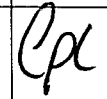


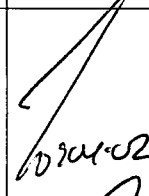
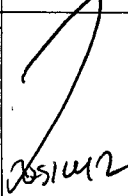
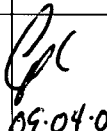


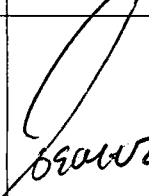
Job Completion



MF 09-06-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3479-041 PAR #: N/A Fault Category: Sm. Fns. NCR: (Yes) No DQA: NA Date: 09.07.07
 Resolution: Re-work Disposition: Re-work QA: N/C Closed: NA Date: 05.07.15

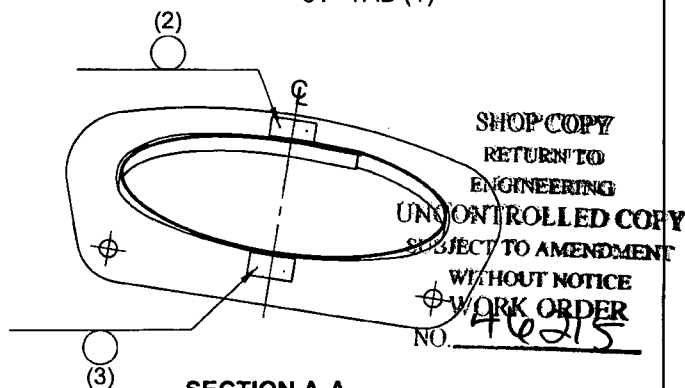
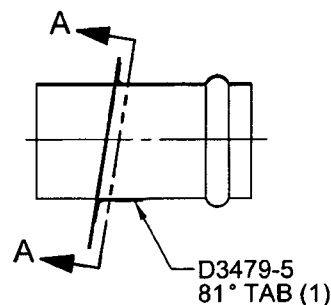
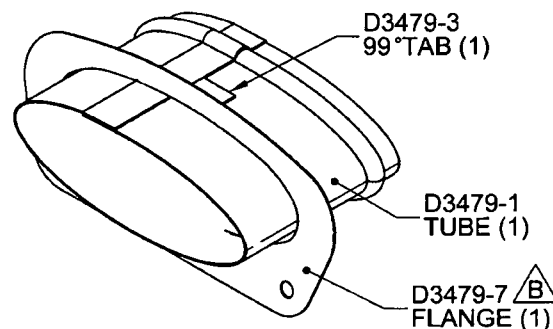
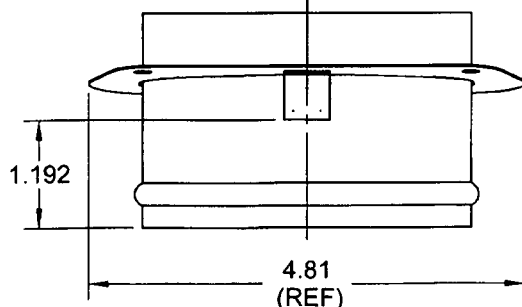
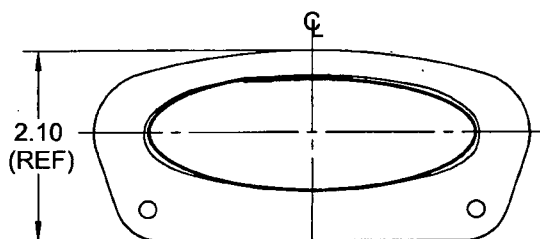
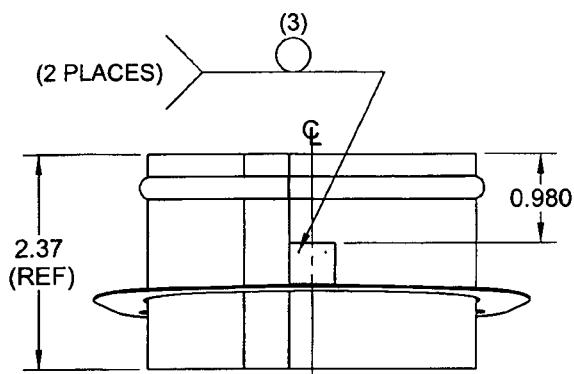
NCR: 46215		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/04/07	5	2 piece have hole with spot welder lot set-up on spot welder 2 first piece were o.k after spot welder came to Rotr R.C. process		Drill hole of .098 make touch up of weld in it N 106762	 09.04.07	 09/06/07		 09/04/07
					 09.04.07	 09/06/07		 09/04/07

NOTE: Date & initial all entries



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DATE 08.12.19		TITLE INLET ADAPTER	SCALE 1:2
A	06.01.19	NEW ISSUE	
B	08.12.19	CORRECT TYPO ON SHT1; ADD TOL ON SHT2; MATL SPEC WAS MIL-S-5019	

RELEASED
09/01/30



D3479-041 INLET ADAPTER

NOTES:

- 1) SPOT WELD PER DART QSI 018
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3479-041 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3479-041	INLET ADAPTER
1	D3479-1	TUBE
1	D3479-3	99 DEGREE TAB
1	D3479-5	81 DEGREE TAB
1	D3479-7	FLANGE

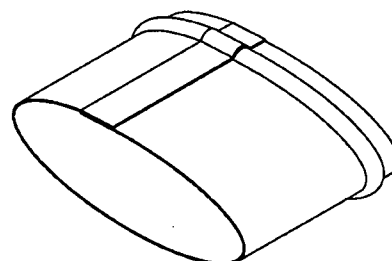
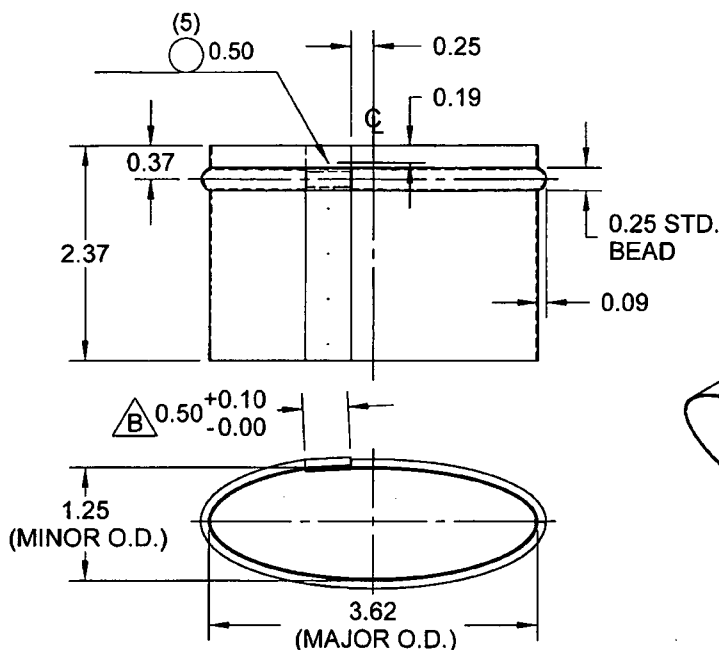
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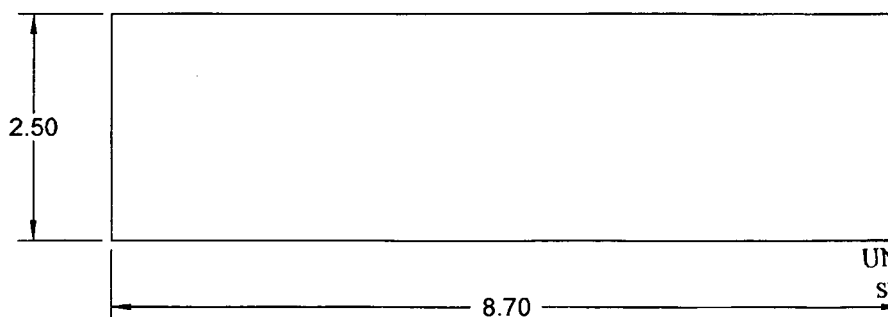


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DATE 08.12.19		TITLE INLET ADAPTER	SCALE 1:2

RELEASED
09/01/2019



D3479-1 TUBE



D3479-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH $\triangle B$
OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) SPOT WELD PER DART QSI 018
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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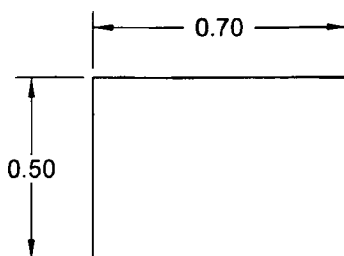
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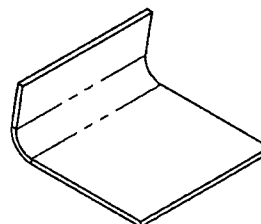
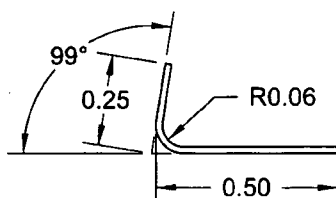
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CHECKED PH	APPROVED #	DRAWING NO. D3479	REV. B SHEET 3 OF 4
DATE 08.12.19		TITLE ADAPTER INLET	SCALE 2:1

RELEASED
09/01/30 MP

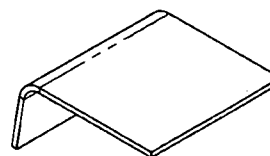
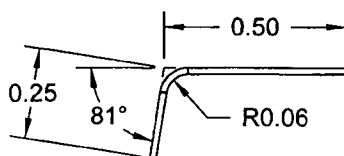


D3479-3F FLAT PATTERN

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH $\triangle B$
OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)



D3479-3 99 DEGREE TAB (MAKE FROM D3479-3F FLAT PATTERN)



D3479-5 81 DEGREE TAB (MAKE FROM D3479-3F FLAT PATTERN)

NOTES:

- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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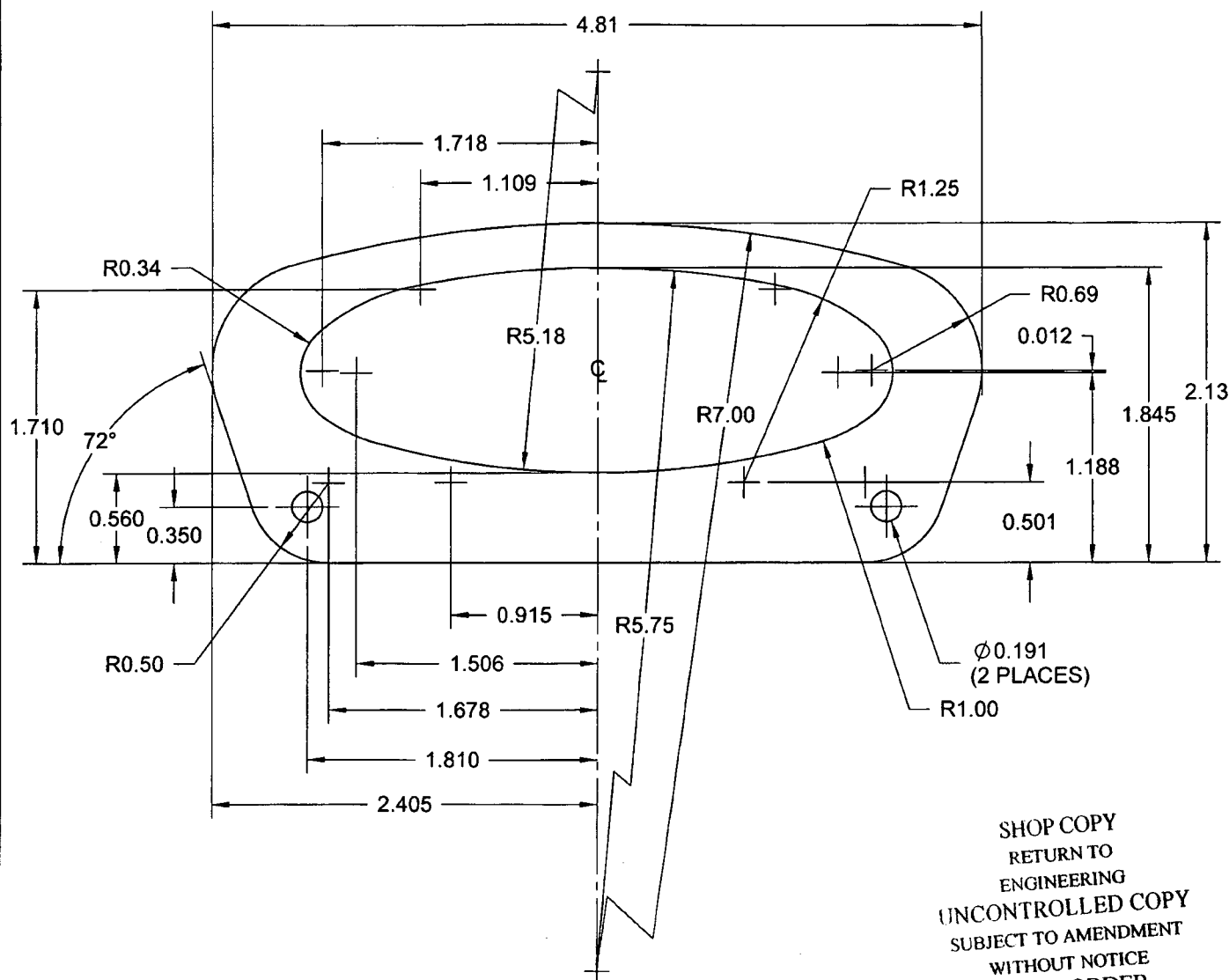
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DATE 08.12.19		TITLE ADAPTER INLET	SCALE 1:1

RELEASED
[Signature]



D3479-7 FLANGE PLATE

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH \triangle_B
OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) PART IS SYMMETRICAL ABOUT CENTERLINE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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SPOT WELD TEST RECORD
AMS-W-6858A
CLASS 'C'

TEST NO#: 64

EMPLOYEE: Frank Frank

PART NUMBER: D3479-041

JOB NUMBER: B 46215

MATERIAL TYPE: 304L

MATERIAL THICKNESS: .018

GROUP SPECIFICATION



Group 1: Aluminum & magnesium



Group 2: Iron; nickel; cobalt



Group 3: Titanium SS

TEST RESULTS

	PASS	FAIL
VISUAL:	[<u>/</u>]	[]
PENETRATION:	[<u>/</u>]	[]
PULL STRENGTH:	[<u>/</u>]	[]

PSI Reading: _____

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 09/09/02

QUALIFIER: SB